

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000835**Date Inspected:** 13-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Ye Yong Jun & Zhu Zhong Hai			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	89 & 77 Mock-Up		

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up Plate #P215-1 (60mm thick 485 material) and #MA25-1 (28mm thick 345 material) weld #MUSB-MA25-15B was in the process of having filler weld material added by welder Gu Caihong #053748.

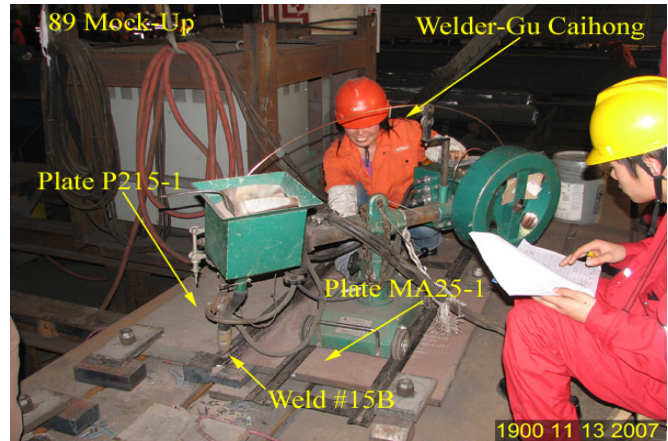
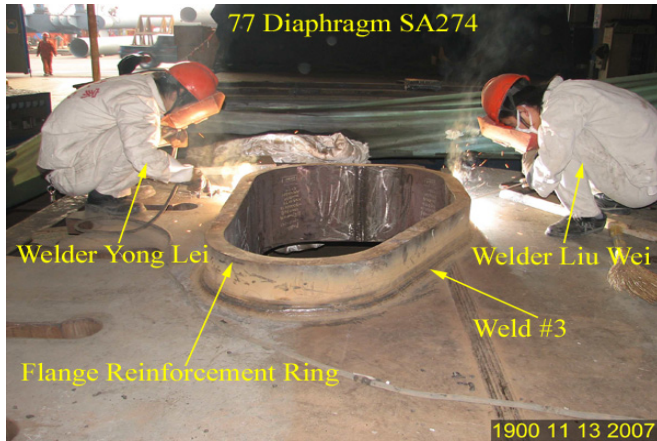
The welder is certified for Shield Metal Arc in the 1G position. The weld procedure used was

WPS-B-T-4221-B-U3-S. The CWI present was Zhu Zhong Hai and the welding parameters recorded by this QA Inspector were, Amps 574, Volts 31, Travel Speed T/S 452 and the Temperature was 194c.

Item-2 77 Diaphragm SA274 Flange Reinforcement Ring to MUSA-SA274 (345 material 60mm thick)& MUSA-SA95 (485 material 90mm thick). Two welders certified for Flux Core Arc Welding in the 3G position were welding weld MUSA-SA102 B/B 3 as per procedure WPS-B-T-4112-3. The welders were (A) Liu Wei #048532 and (B) Yong Lei #040690. Welding parameters recorded by this QA Inspector were, welder (A) Amps 220, Volts 24, Travel Speed T/S 142, Temperature 195c and welder (B) Amps 205, Volts 23, T/S 143 and Temperature 190c. The CWI present was Zhu Zhong Hai.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer